

Work Order ID 55646

January 26, 2010 1:41:51 PM

Item ID: D3999-9

Revision ID:

Item Name: Angle

Start Date: 1/26/10 Start Qty: 1.00

Required Date: 2/03/10 Req'd Qty: 1.00

Reference:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Cust Item ID:

Customer:

Setup Start

Stop

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3999

A-PRELIM

Rev. A

0.00

100



Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg
Dwg Rev: PRE
Prog Rev: PRELIM

0.00

10-1-27

JP 10/01/28 ⑥

10-1-27

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

Pto →

Page 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	130	Bend as per Dwg D3999 perm. chg	SB	10/01/28	1		S 10/01/28
	140	QC 5 S 10/01/28 (6) perm. chg	E	10/01/28		S 10/01/28	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55646

January 26, 2010 1:41:52 PM



Page 2

Item ID: D3999-9

Accept



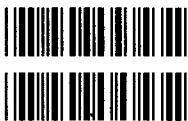
Setup Start



Revision ID:

Item Name: Angle

Stop



Start Date: 1/26/10 Start Qty: 1.00



Cust Item ID:

Required Date: 2/03/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

120



QC

Quality Control

Operation
Description

QC8- Inspect parts - second check

Set Up/
Run-Hours

0.00

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170



Packaging

Packaging

Identify as per dwg & Stock Location:

frederick 0.00

0.00

RE 10-04-22

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

*MF
10-2-19*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 26, 2010 1:41:51 PM

Page 1

Work Order ID: 55646



Parent Item: D3999-9



Parent Item Name: Angle

Start Date: 1/26/10

Required Date: 2/03/10

Comments: IPP rev A 10.01.20 new issue Prelim EC verified by:DD

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

M6061T6S.063



6061-T6 .063 Sheet

Purchased

No

100

sf

316.0657

0.0248



AB 10-1-27

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

MAT	316.0657211
110551	25.4841211
112939	2.5816
113608	288

⑥

110551

POSITIVE RECALL

EFFECTIVE 01/27

RELEASED

AUTH

DATE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

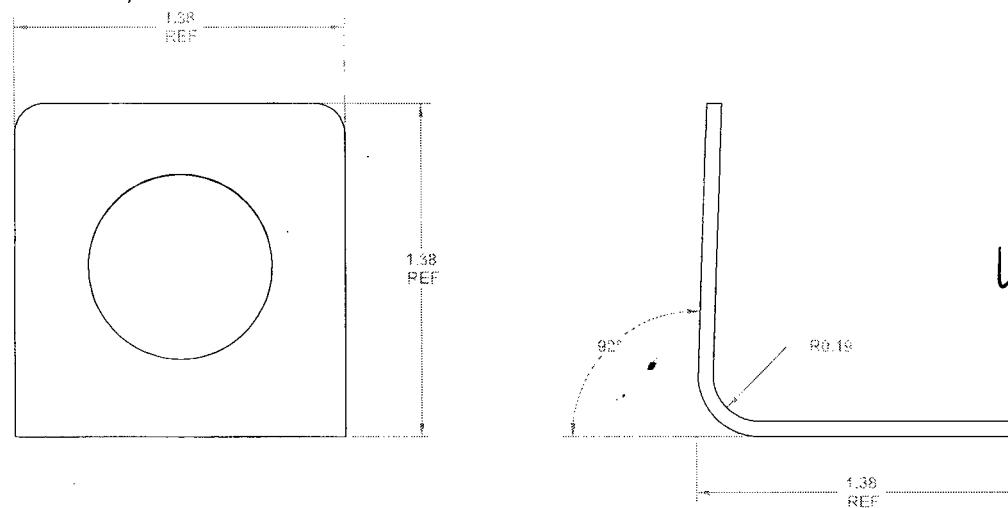
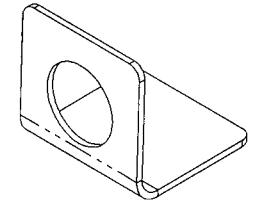
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D3999-9	JCA-M47-1-18



D3999-9 ANGLE

NOTES:

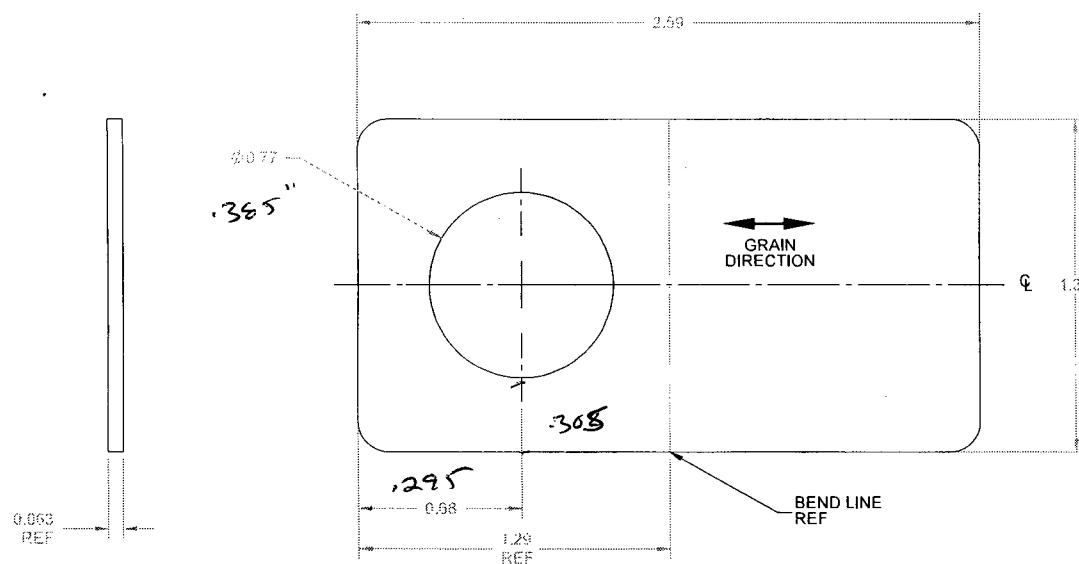
- 1) MATERIAL: MADE FROM D3999-9F
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs

PRELIMINARY ISSUE

09.10.07

DESIGN	<i>[Signature]</i>
DRAWN	<i>[Signature]</i>
CHECKED	<i>[Signature]</i>
MFG. APPR.	<i>[Signature]</i>
APPROVED	<i>[Signature]</i>
DE APPR.	<i>[Signature]</i>
DATE	09.10.07
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO.	D3999
REV.	PA1
SHEET	9 OF 12
TITLE	BAFFLE
SCALE	NTS

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D3999-9F FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S0.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs

PRELIMINARY ISSUE

09.10.07

DESIGN	<i>BB</i>	DART AEROSPACE LTD
DRAWN	<i>BB</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>BB</i>	DRAWING NO.
MFG. APPR.	<i>BB</i>	REV. PA1
APPROVED	<i>BB</i>	SHEET 10 OF 12
DE APPR.	<i>BB</i>	TITLE
DATE	09.10.07	SCALE
		NTS

BAFFLE

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DART AEROSPACE LTD	Work Order:	55646
Description: ANGLE FOR GAS TANK	Part Number:	D3999-9
Inspection Dwg: D3999-9 Rev: PRE Lm PA1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	HB	Audited by:	S	Prototype Approval:	N/A
Date:	10-1-27	Date:	10/01/28	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

8 7 6 5 4 3 2 1

D

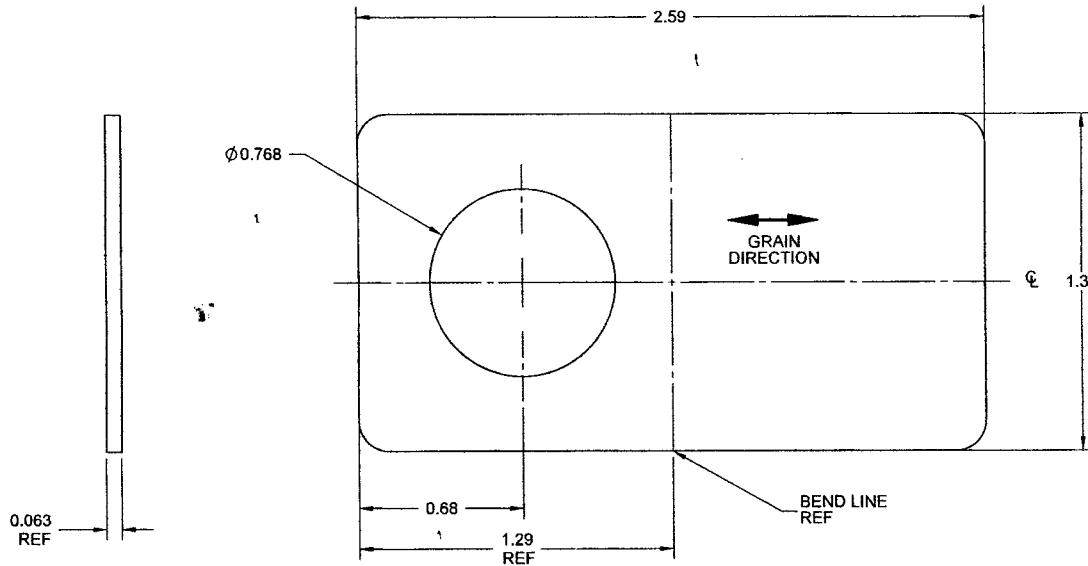
D

C

C

B

B



D3999-9F FLAT PATTERN

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- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs

8 7 6 5 4 3 2 1

DESIGN	<i>BS</i>	DART AEROSPACE LTD	
DRAWN	<i>BS</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>BS</i>		
MFG. APPR.	<i>PE</i>	DRAWING NO.	REV. A
APPROVED	<i>MD</i>	D3999	SHEET 10 OF 12
DE APPR.		TITLE	SCALE
		BAFFLE	NTS
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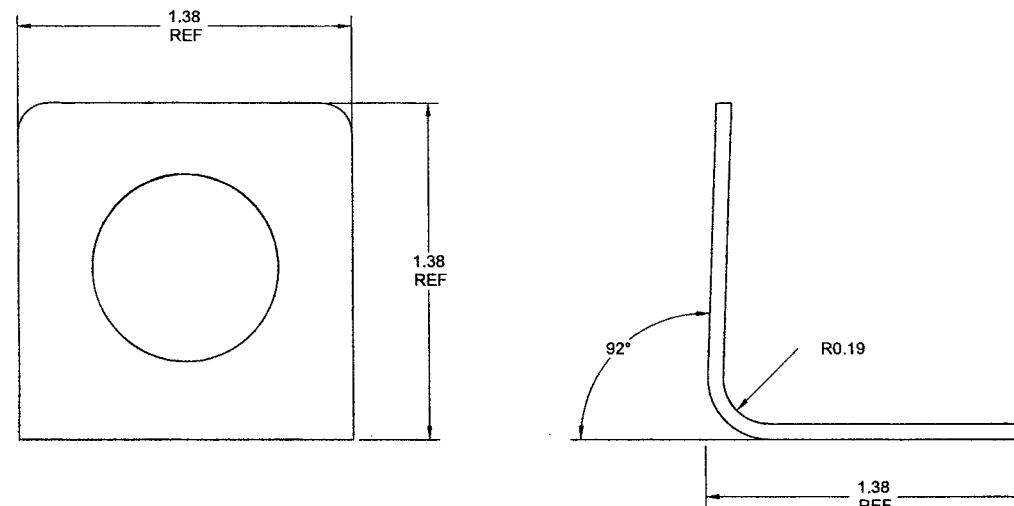
A

8 7 6 5 4 3 2 1

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D3999-9	JCA-M47-1-18

D

D

D3999-9 ANGLE

A

A

NOTES:

- 1) MATERIAL: MADE FROM D3999-9F
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs

8 7 6 5 4 3 2 1

DESIGN	<i>BS</i>	DART AEROSPACE LTD	
DRAWN	<i>BS</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>BS</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>BS</i>	D3999	SHEET 9 OF 12
APPROVED	<i>BS</i>	TITLE	SCALE
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